Work Order ID 70160

Monday, May 30, 2011 12:43:00 PM

Item ID: D3910-1 **Accept**

Revision ID:

Item Name: Crosstube Lug

Setup Start / Stop

Start Date: 5/30/2011 **Start Qty:** 30.00

Required Date: 6/8/2011 **Req'd Qty:** 30.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ___ **Date:** 11-05-30 **Tooling:** ___ **Date:** ___

QC: ___ **Date:** ___ **SPC (Y/N):** ___ **Date:** ___

Run Start / Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3910	B

100

Bandsaw

Jeaspa Bandsaw

Memo

0.00

0.00

~~CUT BLANK 1.450" LONG~~

Cut extrusion @ metec

CL 11/06/02

110

HAAS 1 Purchasing

~~HAAS CNC vertical machine #1~~

Memo

0.00

0.00

~~MACHINE AS PER FOLIO FA865 AND DWG~~
~~FOLIO REV:________~~
~~DWG REV:________~~

CL 11/06/02 30

P/O 14227

DEBURR issue P/O to metec

machine as per dwg D3910 REV. B

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC rec'd Quality Control	~~QC2- Inspect parts off machine EAI/EAIB~~ Memo rec'd + inspect for transit damage attached CofC to W/O	0.00 0.00				CL	11/06/24		(30)
130 QC Quality Control	QC6 Inspect parts - second check Memo	0.00 S 11/06/27 0.00				counts (30)			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				30	BL	11-6-27	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

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NOTE: Date & initial all entries

Work Order ID 70160

Monday, May 30, 2011 12:43:00 PM

Item ID: D3910-1 **Accept**

Revision ID:

Item Name: Crosstube Lug

Setup Start / Stop

Start Date: 5/30/2011 **Start Qty:** 30.00 **Cust Item ID:**

Required Date: 6/8/2011 **Req'd Qty:** 30.00 **Customer:**

Reference:

Run Start / Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating M117745	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum **Memo**	0.00 0.00	Start Time: 11:30 Temp: 320°F Finish Time: 12:00			30X	Ø		11/06/28
160 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				30			11-6-28
170 Packaging Packaging	Identify as per dwg & Stock Location: St507 **Memo**	0.00 0.00				(30)			11/07/04

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70160

Monday, May 30, 2011 12:43:00 PM

Item ID: D3910-1

Accept

Setup **Start**

Revision ID:

Item Name: Crosstube Lug

Stop

Start Date: 5/30/2011 **Start Qty:** 30.00

Required Date: 6/8/2011 **Req'd Qty:** 30.00

Cust Item ID:

Customer:

Reference:

Run **Start**

Stop

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ____________ **Date:** ________

QC: ____________ **Date:** ________ **SPC (Y/N):** ____________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00						11/7/5	
QC	**Memo**	0.00							
Quality Control									

MF

11-07-04

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 30, 2011 12:43:06 PM

Work Order ID: 70160

Parent Item: D3910-1

Parent Item Name: Crosstube Lug

Start Date: 5/30/2011 **Required Date:** 6/8/2011

Start Qty: 30.00 **Required Qty:** 30.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			100	f	221.5400	0.13	4.105263			

CL11/06/02

Location	Loc Qty	Loc Code	
MAT006	221.54		
43722	161.5		
45800	1		
63005	59.04		4.11

D3910-1P

X 30

CL11/06/24

Dart Aerospace Ltd

NOTE

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

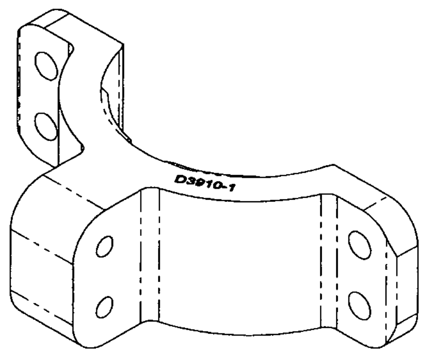
Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

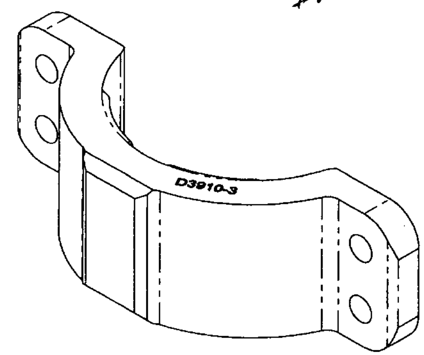
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70160
11-05-30



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

REV.	DESCRIPTION	BY	DATE
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3910 — REV. B — SHEET 1 OF 3
MFG. APPR.		
APPROVED		TITLE X-TUBE LUG (350) — SCALE NTS
DE APPR.		
DATE	10.03.16	

Dart Aerospace Ltd

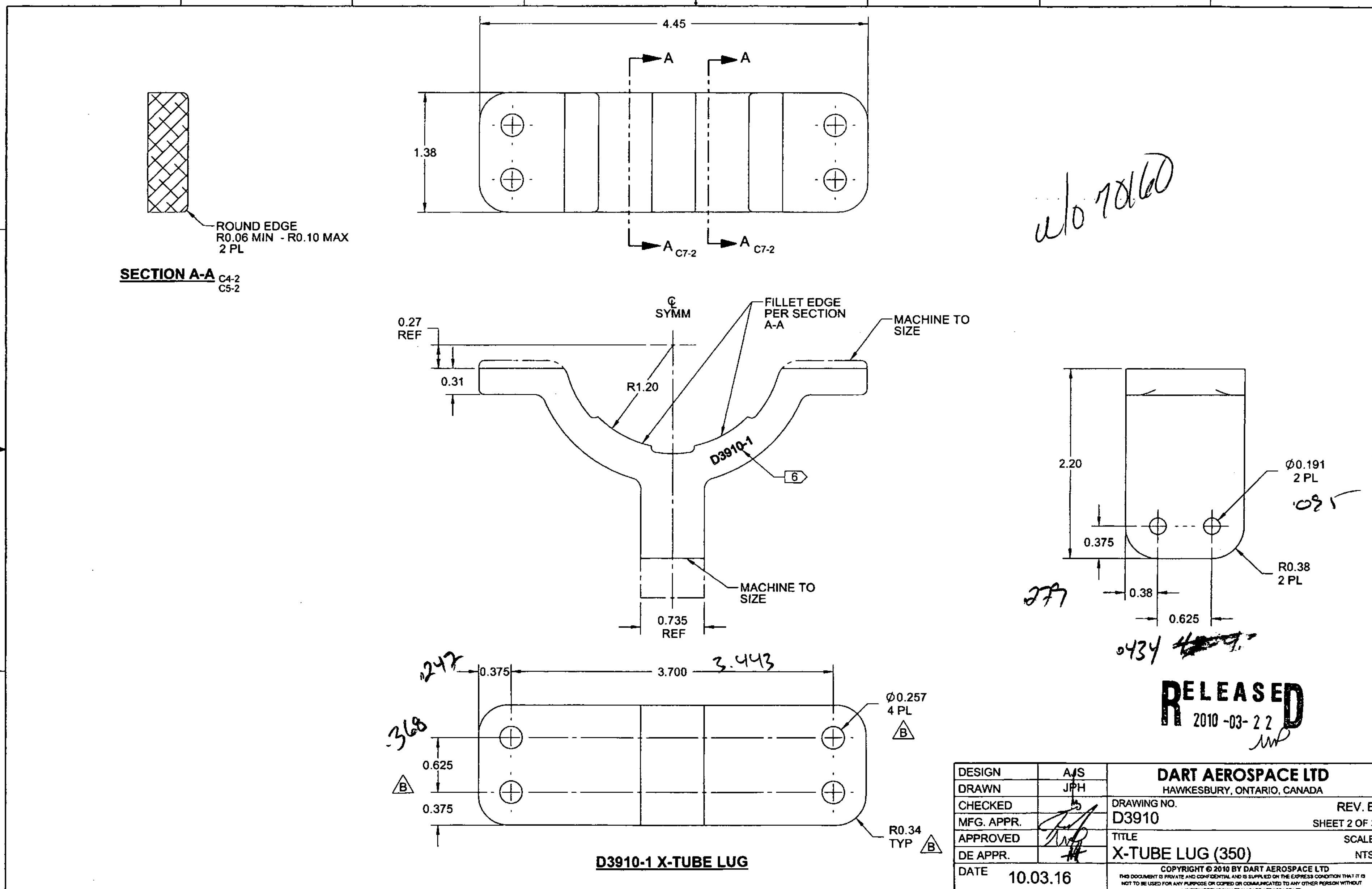
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: ________ Fault Category: ____________________ NCR: Yes No DQA: ______ Date: __________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: __________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



4.45
A
A
1.38
A C7-2
A C7-2
ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL
SECTION A-A C4-2 C5-2
℄ SYMM
FILLET EDGE PER SECTION A-A
MACHINE TO SIZE
0.27 REF
0.31
R1.20
D3910-1
6
MACHINE TO SIZE
0.735 REF
2.20
Ø0.191
2 PL
0.375
R0.38
2 PL
0.38
0.625
0.375
3.700
Ø0.257
4 PL
B
0.625
B
0.375
R0.34
TYP
B
D3910-1 X-TUBE LUG
w/o 7060
.081
.277
.0434
.242
3.443
.368
RELEASED
2010-03-22
DESIGN AJS
DRAWN JPH
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 10.03.16
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3910
REV. B
SHEET 2 OF 3
TITLE X-TUBE LUG (350)
SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD

Dart Aerospace Ltd

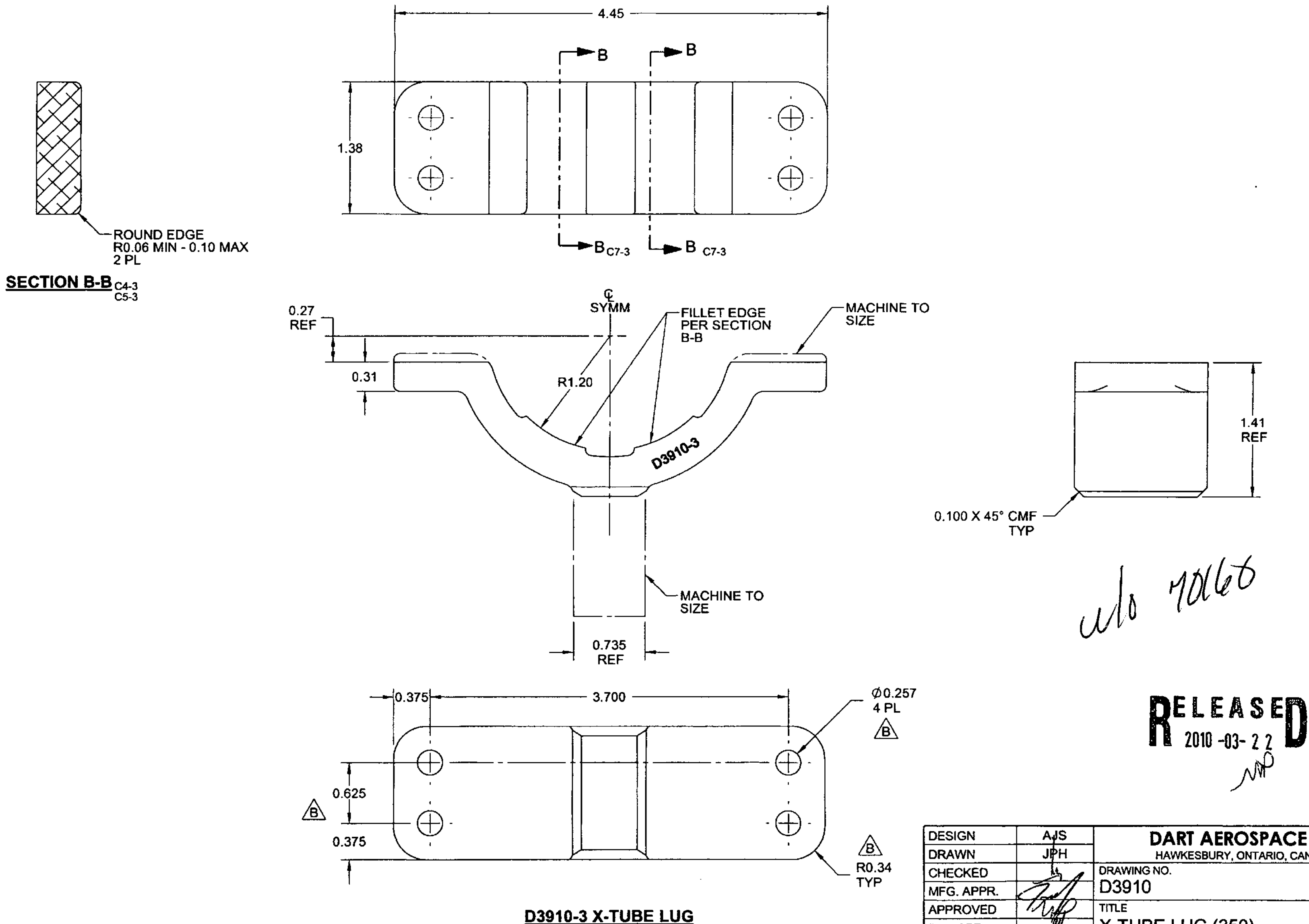
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	DRAWING NO. D3910 — REV. B — SHEET 3 OF 3
CHECKED		
MFG. APPR.		
APPROVED		TITLE: X-TUBE LUG (350) — SCALE: NTS
DE APPR.		
DATE	10.03.16	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14227

Purchase Order Date 6/2/2011
PO Print Date 6/6/2011

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	613 678 3957	**Requisition Nbr**	
Vendor Fax	613 678 3956	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr		**Terms**	Net 30
		Currency	CAD
		FOB	Destination-Collect

REVISED

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference / Revision ID / Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-1P ✓	CROSSTUBE LUG	6/16/2011	30.00	Dart Truck	$31.5500	$946.50
	CX11/06/24		Yes	Each			

Special Inst: MACHINE AS PER DWG D3910
REV. B
B70160

PO Total: **$946.50**

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

CL

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 2 **Change Date:** 6/6/2011

METEC METAL TECHNOLOGY INC.

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0, Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.:

Date: Jun 24, 2011

Page: 1

Sold to:	**Ship to:**
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14227	**Sold By:** Walz, Christian D.
Shipped By:	**Ship Date:**

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-1 Crosstube Lug Material supplied by DART: D2423 B63005 C4110624	Each	30 ✓	30	

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by ______________________

Thank you for your order!

METEC METAL TECHNOLOGY INC.

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
30	D3910-1	Crosstube Lug	14227

MATERIAL: supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, June 24, 2011

20 Terry Fox Drive P.O. Box 781 • Vankleek Hill ON K0B 1R0 • (613) 678-3957 Fax: (613) 678-3956